

IN THE CLAIMS

Please amend the claims as follows:

Claims 1- 15 (Cancelled)

16. (Currently Amended) A ~~process for casting a~~ workpiece, ~~in particular an internally cooled turbine blade or vane, in which casting cores (2) are introduced produced by the process, comprising:~~

introducing casting cores into a casting cavity ~~(1)~~; and
producing passages ~~(3)~~ from the casting cores, which pass through the workpiece, ~~in particular having the features of one or more of claims 1 to 15, characterized in that~~
wherein the casting cores ~~(2)~~ are introduced into the casting cavity ~~(1)~~ in such a manner that they rest loosely against one another.

17. (Currently Amended) The ~~process~~ workpiece as claimed in claim 16, ~~characterized in that~~ wherein the casting cores ~~(2) which have been~~ introduced into the casting activity ~~(1)~~ are subsequently coated with a material which can withstand casting and bonds to them.

Claims 18- 20 (Cancelled)

21. (New) A workpiece as claimed in claim 16, wherein the workpiece is an internally cooled turbine blade.

22. (New) A workpiece as claimed in claim 16, wherein the workpiece is an internally cooled turbine vane.

23. (New) A workpiece as claimed in claim 17, wherein the workpiece is an internally cooled turbine blade.

24. (New) A workpiece as claimed in claim 17, wherein the workpiece is an internally cooled turbine vane.

25. (New) A workpiece as claimed in claim 16, wherein the passages pass through the workpiece in the form of a three-dimensional grid.

26. (New) The workpiece as claimed in claim 16, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.

27. (New) A casted workpiece, comprising:
a wall including passages in the form of a three-dimensional grid, whereby a casted three-dimensional grid coating of the passages is one piece with the remainder of the workpiece.

28. (New) The workpiece as claimed in claim 27, wherein practically a quarter of the total area of a workpiece side is made up by an area of uniformly distributed passage openings.

29. (New) A workpiece as claimed in claim 27, wherein the workpiece is an internally cooled turbine blade.

30. (New) A workpiece as claimed in claim 27, wherein the workpiece is an internally cooled turbine vane.

31. (New) A workpiece as claimed in claim 28, wherein the workpiece is an internally cooled turbine blade.

32. (New) A workpiece as claimed in claim 28, wherein the workpiece is an internally cooled turbine vane.

33. (New) The workpiece as claimed in claim 27, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.

34. (New) The workpiece as claimed in claim 28, wherein passage openings have diameters of between approximately 0.1 and approximately 2 mm.